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## (54) Container end wall

(57) An end wall for a can body has a central panel 7 surrounded by a conventional expansion ring 8 which is connected to an inner wall 16 of a channel portion 5 by a deformable annulus 17, 18 so that when subjected to high pressure during thermal processing of a closed can having this end wall, the deformable annulus changes shape to permanently increase the container volume while the central panel 7 is only temporarily deformed. The deformable annulus protects the side wall and ends of the can from excessive pressure so thinner container materials may be used. The deformable annulus may comprise a flat ledge 17 and a concave annular bead 18. Alternatively, the deformable annulus may consist of a frustocanonical portion (30, Figure 10), optionally provided with hollow stiffening beads, (31, Figure 11). The end wall may be integrally formed with the can body or may be seamed to the body, (Figure 12). The end wall is formed by a press tool comprising an upper tool, with a sleeve and central pad, and a lower tool, with an annular die surrounding a punch, (Figure 9). The can may be used for pet food.

*Fig.5*

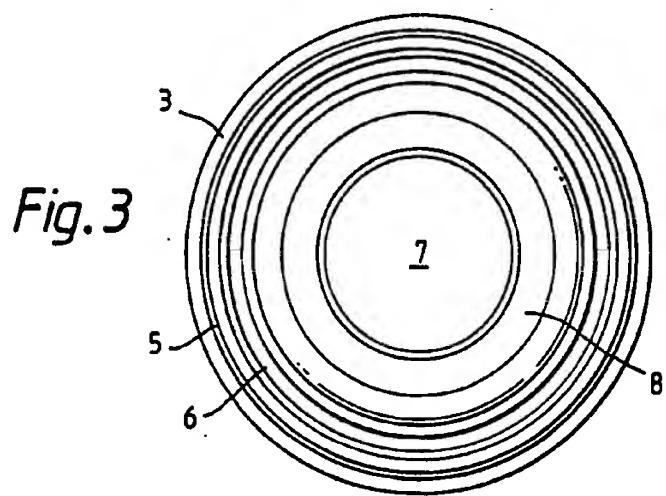
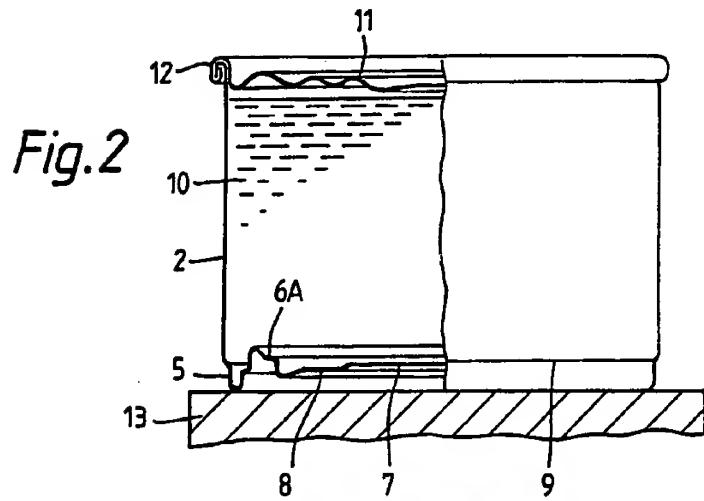
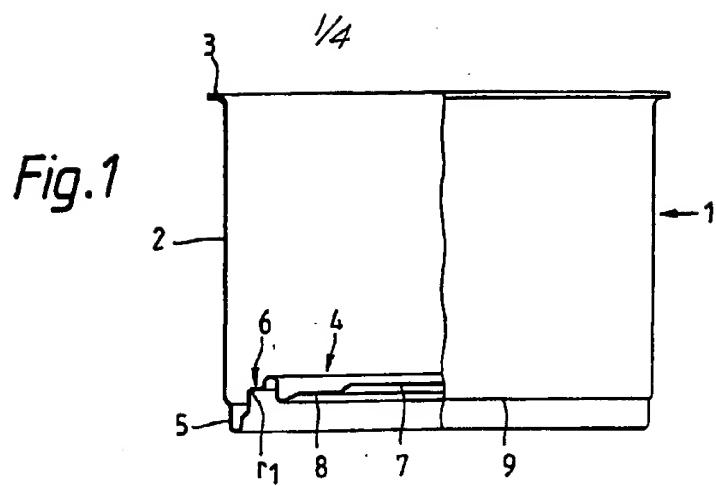


*Fig.7*



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Fig.4

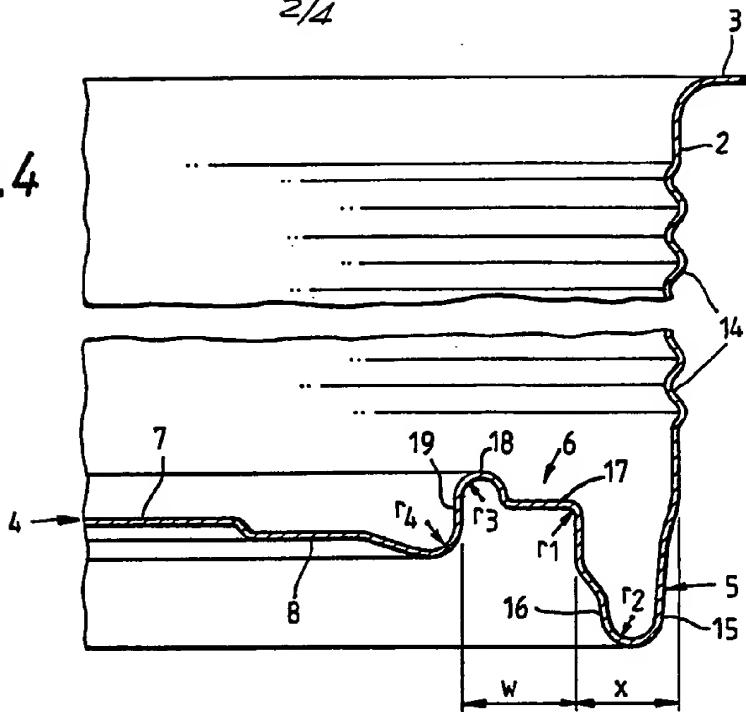


Fig.5

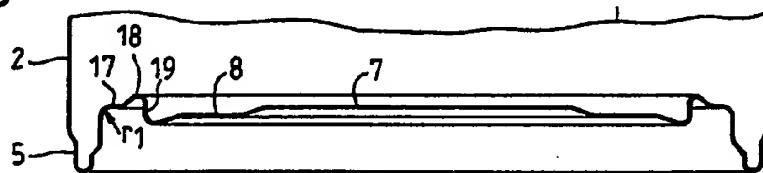


Fig.6

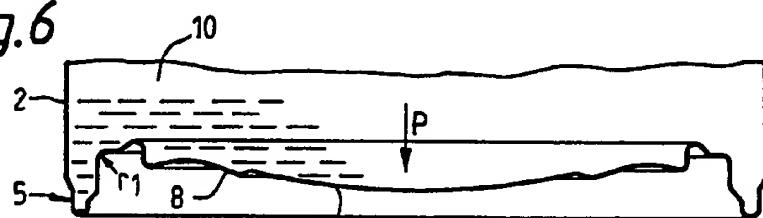
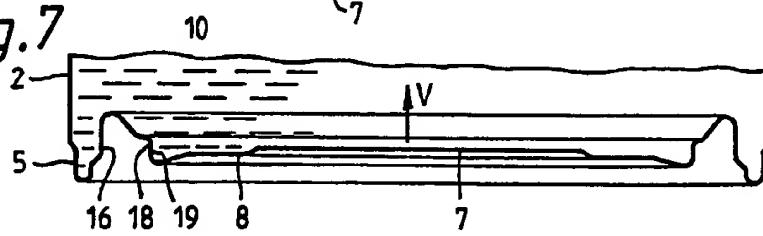
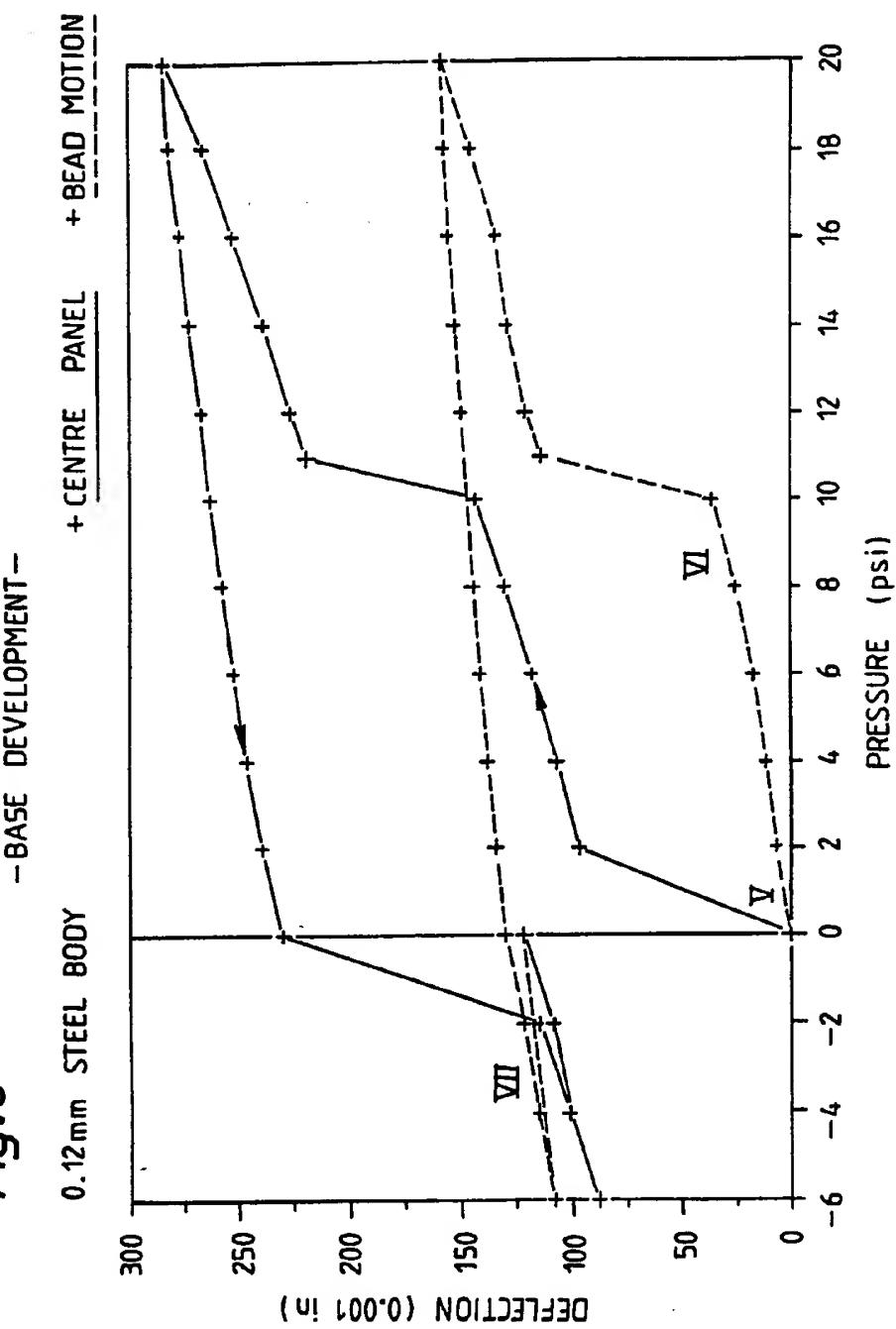


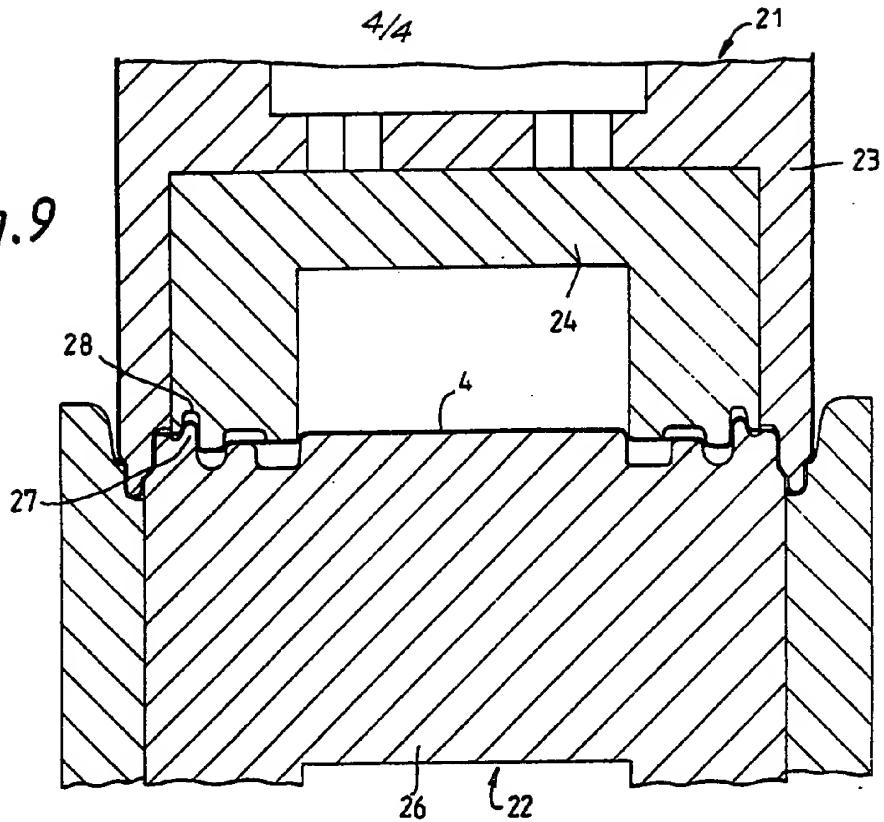
Fig.7



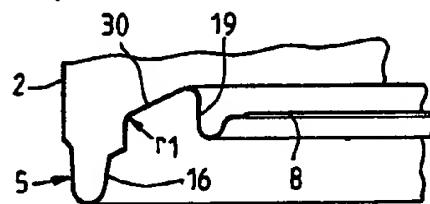
*Fig. 8*



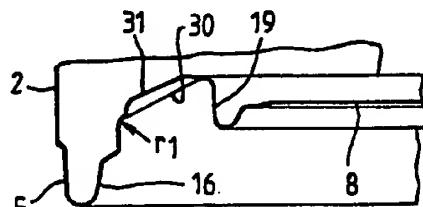
*Fig. 9*



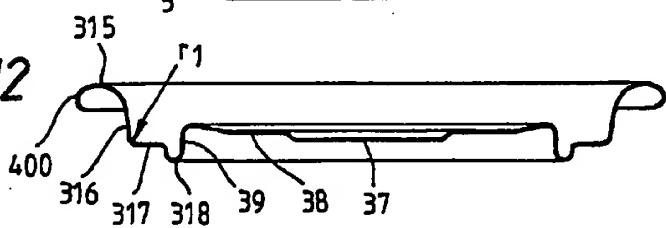
*Fig. 10*



*Fig. 11*



*Fig. 12*



CONTAINERS

This invention relates to metal containers and more particularly but not exclusively to the bottom wall of a container drawn from a circular blank to comprise a bottom wall and a side wall upstanding from the periphery of the  
5 bottom wall.

A widely used container for petfoods, typically 73mm diameter by 56mm tall comprises a substantially flat centre panel surrounded by a flexible annulus which is joined to a channel portion, or stand bead, having an  
10 inner wall joining the flexible annulus and an outer wall joining the side wall of the container. The containers are usually drawn from a lacquered steel such as electrochrome coated steel or tinplate in temper DR8 of thickness 0.17 mm (about 0.007"). The side wall of this  
15 can is vulnerable to damage at point of sale. When the containers are filled, the closing machine applies a top pressure to a can end while a double seam is rollformed to join the can end to the side wall, so the side wall has to be strong enough to support this top load. When the  
20 closed containers are thermally processed the contents of the can expand so pressure develops in the container and the side wall is protected from undue distortion because the flexible annulus permits the bottom wall to bulge outwardly to increase the container volume. As the  
25 container cools, the pressure in the can abates. If the product is hot filled, a partial vacuum may develop in the container when cooled to room temperature so putting the side wall at risk of collapse unless the flexible annulus returns towards original shape.

30 Can ends which provide the desired expansion and contraction in container volume by simple flexure are described in US Patents 3105765 (Creegan) and 3409167 (Blanchard), and in British Patents Publications 2107273 and 2119743 (of American Can Company) but in all these

patents the change of volume available in a filled and closed can is limited to that available from flexure, not permanent change of shape.

These volume change requirements are made more stringent if tall cans having a wall ironed side wall are used because the side wall may be between 0.075mm (0.004") and 0.0125mm (0.005").

A first objective of this invention is to provide a container having an end wall which will provide an increased volume during thermal treatment to reduce the pressures generated within the can during thermal processing. A second objective is to provide some flexibility to compensate for a residual partial vacuum in a filled and closed can. The end wall may be integral with the side wall of a drawn can body or alternatively the end wall may be a can end or lid.

Accordingly, this invention provides a container end wall comprising a peripheral channel portion or cover hook, an inner wall of which supports a centre panel, characterised in that,

a deformable bistable annulus extends both radially and axially inwards away from the inner wall to support a dependent annulus which connects the centre panel to the deformable annulus so that when subjected to pressure inside the container, the deformable annulus is permanently deflected from its initial stable position to its second stable position and the centre panel is temporarily deflected axially outwards. The increase in container volume arising, reduces the pressure generated on the side wall and end walls of the container so that, if desired, thinner metal may be used. The centre panel may have at least one flexible expansion ring surrounding a central panel portion.

In one embodiment, the deformable annulus comprises a substantially flat annular portion which extends radially inwards from the inner wall of the channel portion or

cover hook and surrounds an annular bead of arcuate cross-section which extends away from the inner wall before turning to join a dependent substantially cylindrical wall portion which connects the centre panel 5 and ring to the deformable annulus.

An outer wall of the channel portion may have a peripheral cover hook for attachment to the flange of the side wall of a container body; or alternatively the outer wall of the channel portion may connect with the side wall 10 of a can body drawn from a blank.

In another embodiment the deformable annulus is frustoconical and may, if desired, be provided with a plurality of stiffening beads which extend across its width to bias the deformable panel to either its original 15 shape or its deformed shape.

In preferred embodiments the radial width of the deformable annulus is greater than the width of the channel portion. The channel portion preferably comprises an inner wall joined to an outer wall by a bead of arcuate 20 cross-section typically or the order of 1.0mm (about 0.004").

The inner wall and deformable panel are connected by a radius of the order of 0.7mm (0.003"), at which bending takes place as the deformable annulus moves.

25 Various embodiments will now be described by way of example and with reference to the accompanying drawings in which:

Fig.1 is a part sectioned side view of a can body drawn from a sheet metal blank;

30 Fig.2 is a like view of the can body of Fig.1 after filling, closing, heating and cooling;

Fig.3 is an underplan view of the can body of Fig.1;

Fig.4 is an enlarged fragmentary section of a preferred embodiment of the can body;

Figs.5, 6 and 7 are diagrammatic sectional views of the can bottom when empty, after filling and closing but

during early heating of a thermal process, and after final cooling of the processed can to ambient temperature.

Fig.8 is a graph of bottom wall deflection plotted against internal pressure in the closed can;

5 Fig.9 is a diagrammatic sketch of a press tool with formed can body.

Fig.10 is a fragmentary section of a first alternative embodiment of an end wall profile;

10 Fig.11 is a fragmentary section of the end wall of Fig.10 with additional beads; and

Fig.12 is a side view of a can end sectioned on a diameter.

Figs.1 and 3 show a can body, 73mm diameter x 56mm tall, drawn from a circular blank of lacquered 15 electrochrome coated steel or tinplate 0.12mm thick, comprising a cylindrical side wall 2 terminating at one end in an outwardly directed flange 3 and closed at the other end by an integral bottom wall 4. The bottom wall comprises a peripheral channel portion 5, a deformable 20 annulus 6 and a central panel 7 surrounded by flexible expansion panels 8. The central panel 7 can be seen to be held at a level just above an optional stacking ledge 9 in Fig.1.

Fig.2 shows the can body of Fig.1 after filling with 25 a product 10 and closing by a can end 11 attached to the flange of the body by a double seam 12. Under the influence of pressure arising during heating of this closed can to thermally process the product, the deformable annulus 6 has been deflected from the generally 30 upward attitude shown in Fig.1, by bending at radius  $r_1$  to the generally downward attitude 6A shown in Fig.2.

Consequently the internal volume of the closed can body has been permanently increased by about 10ml. However, the central panel 7 and its expansion rings continue to move under the influence of internal pressure in the can so that as the product cools and a partial vacuum

develops, the centre panel is pulled towards its original shape.

As shown in Fig.2 the fully processed can is able to stand on a flat surface 13 with the central panel 7 just 5 below the level of the stacking bead 9 but clear of the support surface 13.

Fig.4 shows a details of a preferred embodiment of the can body described with reference to Fig.1. In Fig.4, the side wall has been provided with a plurality of hoop 10 beads 14 which stiffen the thin side wall metal against expansion or collapse so that the top end and bottom wall of the can have to provide movement to accommodate pressure change as the can and contents are thermally processed.

15 The channel portion 5 could usefully have an outer wall 15 coaxial with the side wall and a simple cylindrical inner wall 16 joined by an annular bead of arcuate cross-section radius  $r_2$ . However, as shown in Fig.4, the outer wall 15 is of reduced diameter to permit. 20 stacking of the can body inside the double seam 12 of a lidded can, as shown in Fig.2. The inner wall 16 is also stepped to give clearance for the pull tab of tear open can end (not shown) which may be required on some cans.

In Fig.4, it will be seen that the deformable annulus 25 6 comprises a flat annular ledge 17 which surrounds an outwardly concave annular bead 18 of radius  $r_3$  upstanding from the inner periphery of the ledge before it turns downwards to a dependent cylindrical wall portion 19 that joins the periphery of the periphery of the flexible panel 30 8 at a radius  $r_4$ . The flexible panel 8 and centre panel 7 behave conventionally as will be understood in the art.

Typical dimensions for the bottom wall shown in Fig.4 are:

$r_1$ deformable annulus/inner wall	0.1mm
$r_2$ stand bead radius	0.8mm
$r_3$ radius of bead 18	0.75mm

$r_4$ dependent wall to flexible panel	0.7mm
w radial width of deformable annulus	5.0mm
x maximum width of channel	3.5mm

It will be noticed that the deformable annulus is 5 wider than the channel portion so that it receives a greater pressure thrust force than the channel which is designed to remain stiff and unmoved.

Fig.5 is presented to show the bottom profile of the empty can body on a larger scale to permit comparison with Figs.6 and 7, and understanding of the graph Fig.8.

Fig.6 shows the bottom wall 4 of the can body at an early stage in the heating of the filled and closed can. Expansion of the product 10 has increased pressure  $p$  in the can to distend the central panel 7 and flexible panel 15 8 so that the inner periphery of the deformable annulus 6 is subjected to a downward force.

Fig.7 shows the bottom wall 4 after the processed can and contents have been cooled to ambient temperature and a partial vacuum V has developed to pull the centre panel 7 20 and flexible ring 8 towards their original unpressurised shape. In Fig.7, it can be seen that the deformable annulus 6 has hinged downwards at radius  $r_1$ , the flat ledge 17 has become approximately frustoconical to extend radially inwards and axially into the inner wall 16 and 25 the radius  $r_3$  has been opened out to almost a ledge 18A so that the cylindrical wall portion 19 has moved to lower the central panel portions 7, 8 and create a permanent additional volume of about 10ml.

In Fig.8 the pressure inside the can during thermal 30 processing is plotted against movement of the centre of the central panel 7 (full lines) and movement of the bead portion 18 of the deformable annulus (dashed lines). As pressure rises from atmospheric (denoted 0) the centre panel starts to move quickly but the bead motion rises more slowly (see V on graphs indicating the shape shown in Fig.5).

At about 10psi overpressure in the can there is a sudden rise in both movement graphs (see VI denoting the can shape shown in Fig.6) because the deformable panel starts to change shape rapidly and accommodate the 5 increasing pressure in the can. In this trial, the maximum internal pressure was raised to 20psi by which pressure the centre panel was moved 0.275" (6.9mm) and the bead 18 was moved 0.150" (3.7mm). On cooling, the centre of the can bottom returns to the shape of Fig.7 denoted 10 VII on the graph, with a resultant increase of 5% in contained volume (10ml in 210ml).

The benefit arising from this increase in container volume is that the thin side wall and end components are protected from pressure which may reform or burst them. 15 Therefore it is possible to use thinner container materials. The thinner wall material may, if desired, be reinforced by hoop panelling as described or made expandable by vertical panels designed to flex inwards and outwards, if desired.

20 Fig.9 shows a press tool 20 in which the bottom wall 4 of the can body 1 is formed between an upper tool 21 and a lower tool 22. The upper tool comprises a sleeve 23 which surrounds a centre pad 24. The lower tool comprises an annular die 25 which surrounds a punch 26. The radius 25 between the inner wall 16 and deformable annulus 6 are formed by closing of the tools 21, 22 together. In order to achieve the desired value of radius  $r_1$  and  $r_2$  an annular punch bead 27 pushes metal into centre pad groove 28 to pull the metal tight so that, on parting of the 30 tools 21, 22 the radii 21, 22 are correctly defined.

Fig.10 shows an alternative shape for the deformable annulus in which the flat ledge 17 and bead 18 are replaced by an upwardly and inwardly extending frustoconical portion 30. In other respects the bottom wall is similar to the bottom wall shown in Fig.4 so the same integer numbers are used to denote the dependent wall

19 and inner wall 16 of the channel.

Fig.11 shows a modified form of the wall of Fig.10 in which the frustoconical deformable annulus 30 is provided with a plurality of equispaced hollow beads 31 to stiffen 5 the annulus and encourage it to suddenly evert from the upwardly inclined shape to a downwardly inclined shape as pressure in the can rises.

Fig.12 shows a can end suitable for fixing to a can body by means of a double seam. This can end uses the 10 principles hereinbefore discussed to provide a permanent increase in container volume during thermal processing.

In Fig.12 the can end comprises a flat central panel 37, an annular expansion ring 38 surrounding the central panel, an annular wall 39 depending from the periphery of 15 the expansion ring 38, an outwardly concave bead 318 which turns outwardly from the annular wall, an annular ledge 317 extending outwardly from the bead 318, an inner wall 316 of a channel portion 315, which extends to a peripheral cover hook 400.

20 The annular ledge 317 and bead 318 behave in the manner described above under the influence of pressures arising during thermal processing of a filled can so that this can end may be used to protect the thin side wall or ends of a can having a side seam or made by deep drawing 25 of a blank. This can end may, if desired, provide volume change additional to that available from a similarly profiled can bottom.

C L A I M S

1. A container end wall comprising a peripheral channel portion or cover hook, an inner wall of which supports a centre panel, characterised in that,  
A deformable bistable annulus extends both radially  
5 and axially inwards away from the inner wall to support a dependent annulus which connects the centre panel to the deformable annulus so that when subjected to pressure inside the container, the deformable annulus is permanently deflected from its initial stable position to  
10 its second stable position and the centre panel is temporarily deflected axially outwards.
2. A container end wall according to claim 1 wherein a central panel comprises a central panel portion surrounded by at least one flexible expansion panel which  
15 is connected to the deformable annulus by a stiff substantially cylindrical wall portion.
3. A container end wall according to claim 1 or claim 2 wherein the deformable annulus comprises, in its initial stable position, a substantially flat annular  
20 portion which extends radially inwards from the inner wall and surrounds an annular bead of arcuate cross-section which extends axially away from the flat annular portion before turning to join the dependent annulus.
4. A container end wall according to any preceding claim  
25 wherein an outer wall of the channel portion is a peripheral cover hook for attachment to the flange of the side wall of a container body.
5. A container end wall according to one of claims 1 to 3 wherein the outer wall of the channel portion connects with the side wall of a can body drawn from a blank.
- 30 6. A container end wall according to any preceding claim wherein the deformable annulus is frustoconical.

7. A container end wall according to claim 5 wherein the frustoconical deformable annulus has a plurality of stiffening beads which extend across its width.
8. A container end wall according to claim 5 wherein the 5 radial width of the deformable annulus is greater than the width of the channel portion.
9. A container end wall according to any preceding claim wherein the inner wall and deformable panel are connected by a radius of the order of 1.0mm.
- 10 10. A container end wall according to claim 3 wherein the radius of curvature of the annular bead is of the order of 0.75mm.
11. A container end wall substantially as hereinbefore described with reference to Figs.1, 2 and 3, Figs.6, 7, 8  
15 and 9, Fig.10, Fig.11 or Fig.12 of the accompanying drawings.

Patents Act 1977

Examiner's report to the Comptroller under  
Section 17 (The Search Report)

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5 B65D 1/40, 1/42, 1/44, 1/46,  
(ii) Int CI (Edition ) 8/04, 8/08, 8/12, 8/14

Search Examiner

LINDA HARDEN

Databases (see over)

(i) UK Patent Office

(ii)

Date of Search

20 AUGUST 1993

Documents considered relevant following a search in respect of claims

1-11

Category (see over)	Identity of document and relevant passages		Relevant to claim(s)
A	GB 2119743 A	(AMERICAN CAN CO)	1
A	GB 2107273 A	(AMERICAN CAN CO)	1

SF2(p)

at - doc99\fil000850



Category	Identity of document and relevant passages -12-	Relevant to claim

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